

Date: Monday, 8/13/2007 3:47:21 PM  
User: Jean-Luc Menard

# **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET, GAS SPRING
Job Number	: 33883	Part Number	: D2144
Estimate Number	: 10179	Drawing Number	: D2144 REV. D
P.O. Number	: <i>N/A</i>	Project Number	: <i>N/A</i>
This Issue	: 8/13/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: D
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Due Date	: 8/20/2007
Previous Run	: 31782	Qty:	50 Um: Each
Written By	<i>JLM / 07-08-13</i>		
Checked & Approved By	:		
Comment	: Est D 04.05.06 Reformat KJ/RF Est Rev:E Now on Waterjet 06-10-15 JLM		

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0945 sf(s)/Unit Total : 4.7250 sf(s)

304/316 .063 Sheet 16GA

Batch: *M105130* *IB 07-08-14*

2.0	WATER JET <i>105130</i>	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2144

Dwg Rev: *D*

Prog Rev: *D* *IB 07-08-14*

2-Deburr if necessary

*(S2)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 07-08-14*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*IB 07-08-14*

*counter*

*X52*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary *and pass open holes to finished size ml 07/08/23*

*X51*

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Part Number: D2144

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: D

SB 07/08/28

(S)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/28 counter (S)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004  
2- Grind flush

07/09/17 (S)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-09-17 (S)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/17 counter (S)

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068

M-1 07/09/18

(SIX)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/09/18 (S)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5210

07/09/18 (SIX)

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Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 5/15/19

Job Completion



h 5/15/19

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	<b>D2144</b>
<b>Inspection Dwg:</b> D2144	<b>Rev:</b> D	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.381	X			
3.022	+/-0.010	3.022	X			
2.468	+/-0.010	2.468	X			
1.913	+/-0.010	1.913	X			
1.555	+/-0.010	1.555	X			
4.126	+/-0.010	4.129	X			
3.465	+/-0.010	3.465	X			
0.340	+/-0.010	0.340	X			
0.625	+/-0.010	0.625	X			
1.000	+/-0.010	1.000	X			
1.083	+/-0.010	1.083	X			
1.660	+/-0.010	1.660	X			
2.312	+/-0.010	2.313	X			
2.844	+/-0.010	2.844	X			
3.294	+/-0.010	3.294	X			
Ø0.257	+0.006/-0.001	0.256	X			
Ø0.171	+0.005/-0.001	0.171	X			
Ø0.320	+0.006/-0.001	0.320	X			
0.354	+/-0.010	0.354	X			
0.063	+/-0.010	0.060	X			

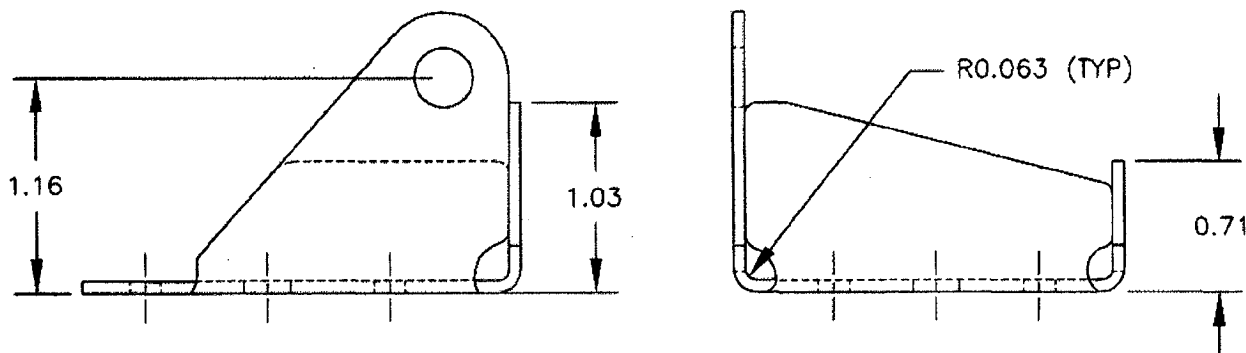
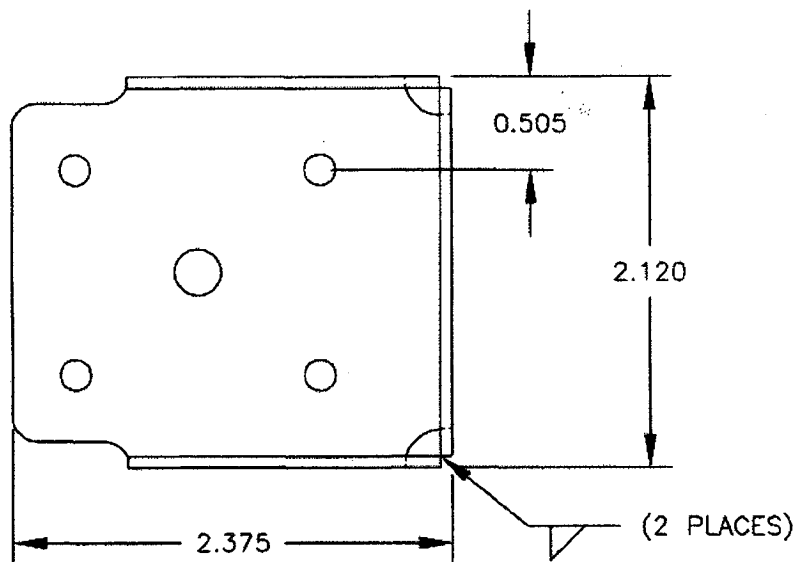
<b>Measured by:</b> IB	<b>Audited by:</b> ER	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07-08-14	<b>Date:</b> 07/08/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	



RELEASED  
98.10.15 KE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
Bw		KE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MA	APPROVED	KE	DRAWING NO.	REV. 0
DATE		DATE		D2144	SHEET 1 OF 2
98.10.08		TITLE		HINGE BRACKET	SCALE
A		95.03.17		NEW ISSUE	1:1
C		96.06.05		FLAT PATTERN LAYOUT ADDED	
D		98.10.08		UPDATED DIMS AFTER BEND (TSR A917)	

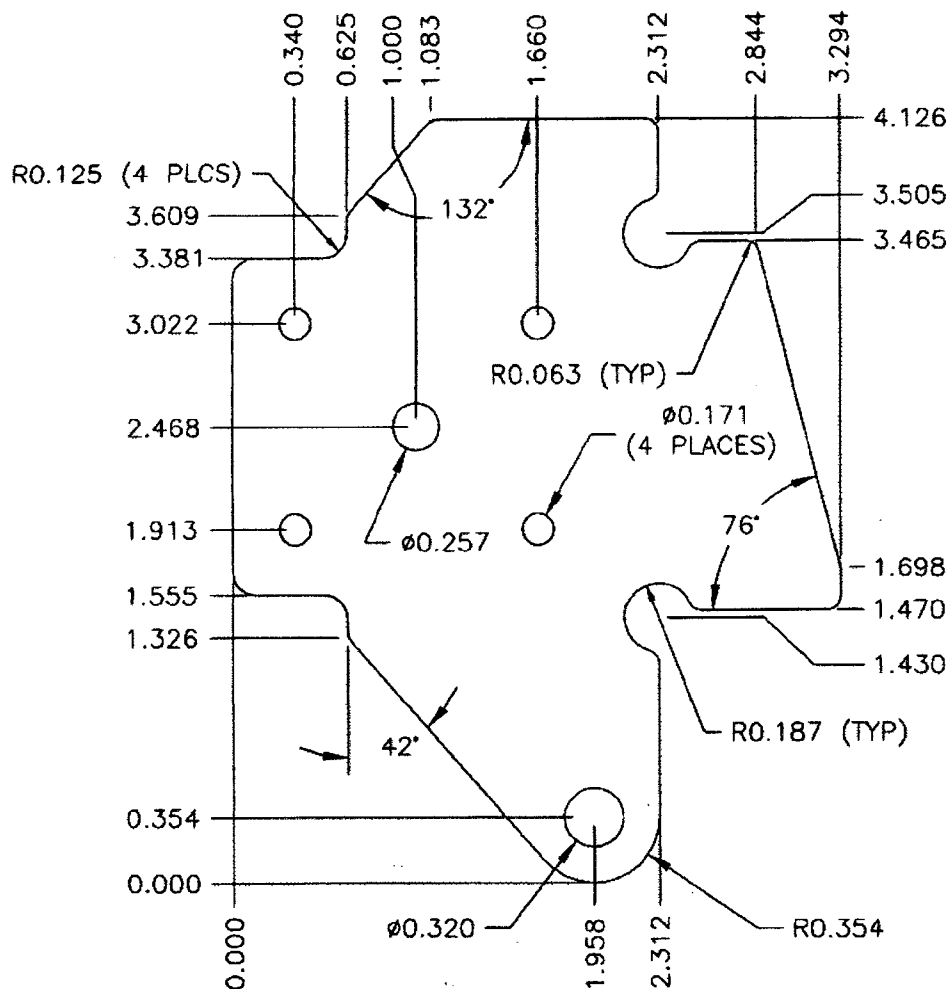


FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DWH	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1

RELEASED  
98.10.15 KB



### D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES